



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-667-207BL
Job Sheet 186179



Part No: D206-667-207BL

Job Qty: 1 ea

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

7124

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Crosstubes-1		GP 2018-11-19
110	CNC Bend Crosstubes	1 pcs		12/14/18	0.00	4.35	CNC Bend Crosstube		GP 2018-11-19
120	QC	1 pcs		12/14/18	0.00	0.00	QC15		38
130	Crosstubes	1 pcs		12/14/18	0.00	2.86	Crosstubes-1		GP 2018-11-27
140	HandFXtube	1 pcs		12/14/18	0.00	0.55	HandFinish5		GP 2018-11-27
150	QC	1 pcs		12/14/18	0.00	0.00	QC7-1		38 DAS
160	QC	1 pcs		12/14/18	0.00	0.00	QC5		9-89 38
170	Outsource	1 pcs		12/14/18			SKY002-VC	1	2018-11-30
180	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging2		DEC 19 2018
190	QC	1 pcs		12/14/18	0.00	0.00	QC5		38
200	Outsource	1 pcs		12/14/18			ATE003-VC		MR
205	Packaging 195 Spray	1 pcs	Paint	12/14/18	0.00	0.00	Packaging2 Spray Paint		AR 18-12-3
210	QC	1 pcs		12/14/18	0.00	0.00	QC14		
220	Crosstubes	1 pcs		12/14/18	0.00	2.86	Crosstubes-1		AR 18-12-7
230	Crosstubes	1 pcs		12/14/18	0.00	1.91	Crosstubes-1		AR 18-12-7
240	QC	1 pcs		12/14/18	0.00	0.00	QC5		38
250	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging1-2		DAS 9-89 DEC 19 2018
260	QC	1 pcs		12/14/18	0.00	0.00	QC4		46 DEC 19 2018
265	DC	1 pcs		12/14/18	0.00	0.00	DC		DAS 9-89 DEC 19 2018
270	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-1		21 DAS 46 DEC 19 2018
280	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		9-89 21 9-89 DEC 19 2018

Part Op 110 - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

Descriptions: 120 - QC15- Crosstube Dimensional Check

130 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole

140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

150 - QC7-Inspect Chemical Conversion Coat

160 - QC5- Inspect part completeness to step on W/O

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

V	 Container No: S129117 Part: D206-667-207BL Job No: 186179 Serial No/Batch: S129117 Revision: Inspector: Exp Date: Instructions: TC STC SH01-5 Issue 3p.daa, STC SR01304NY 05/12/15, JCAB JAI	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Cross tube ☐</td> <td style="width: 33%;">Water Jet ☐</td> <td style="width: 33%;">Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐												
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐												
Finishing ☐	Rec/Store/Packaging ☐	Other ☐												
Composite ☐	Supplier ☐													
D:	Disposition	MRB (QSI042) Approval												
		Completed By												
		Lead hand / Supervisor Approval Verification												
		QC / QA Coordinator Approval												

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

170 - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O 241902 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

190 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247

200 - ISSUE PO *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: Prime 5135773 PAINT: DELFLEET BLUE 138785 Start Time: _____ Finish Time: _____ CLEAR DELFLEET B 5130712

205 - Receive & Inspect for Damage & Mat'l Certs

210 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

220 - 1-Install nut plates as per Dwg D206-667-247.

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 5138976 3- Torque bolts as per dwg exp 6/19

240 - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

265 - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207 Location: _____ PPP Rev: _____

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-247TRN	Crosstube Assembly, Mid Aft	1 Ea (1 ea)	90-Start up Operation	<u>5012422</u>
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	220-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	220-Crosstubes	
MS20601-AD4W10	Rivet	14 Ea (14 ea)	220-Crosstubes	
D2892-1	Support	2 Ea (2 ea)	230-Crosstubes	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	230-Crosstubes	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging	<u>5089283</u>
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	<u>5058983-1</u>
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging	<u>5012410</u>
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging	<u>5093092</u>
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging	<u>5058003</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D206-667-247TRN	1	12	0
220-Crosstubes	D2873-043 <u>5090584</u>	<u>2</u>	33	0
	D2873-045 <u>5125817</u>	<u>2</u>	21	0
	MS20601-AD4W10 <u>5019432</u>	<u>14</u>	195	0
230-Crosstubes	D2892-1 <u>5039250</u>	<u>2</u>	16	0
	D3595-063-450 <u>5127225</u>	<u>4</u>	48	0
	MS21920-22 <u>5105481</u>	<u>4</u>	77	0
250-Packaging	AN5-10A	10	253	0
	AN5-32A	4	525	0
	AN5-34A	4	79	0
	MS21042L5	4	455	0
	NAS1149D0563J	18	1,372	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

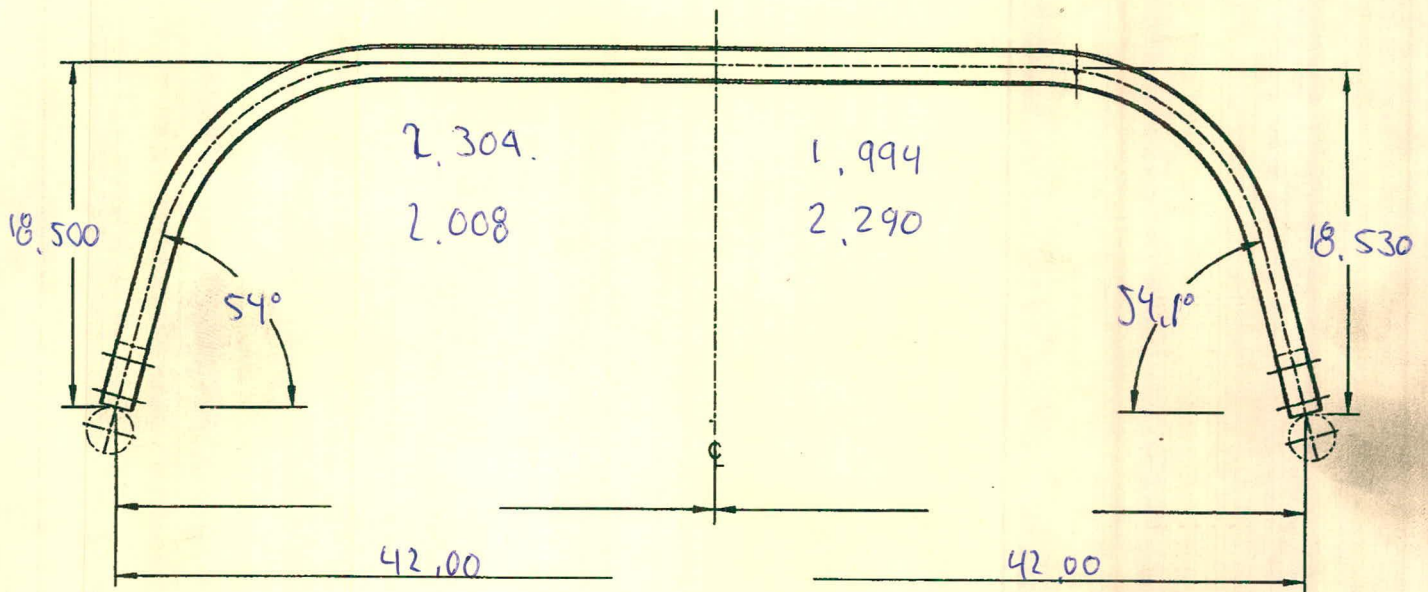
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER :																																																															

DART AEROSPACE LTD		Work Order:	186179
Description: Crosstube Mid Aft (206L)		Part Number:	D206-667-207
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	10	10
Crushing	6.9%	6.9%
Comments		
Acceptable per DR-1059 Rev. A		
DAS 12 18/11/21		
9-89		

QC15 Inspection	EB
Date	18-11-20

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

240
21
22

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

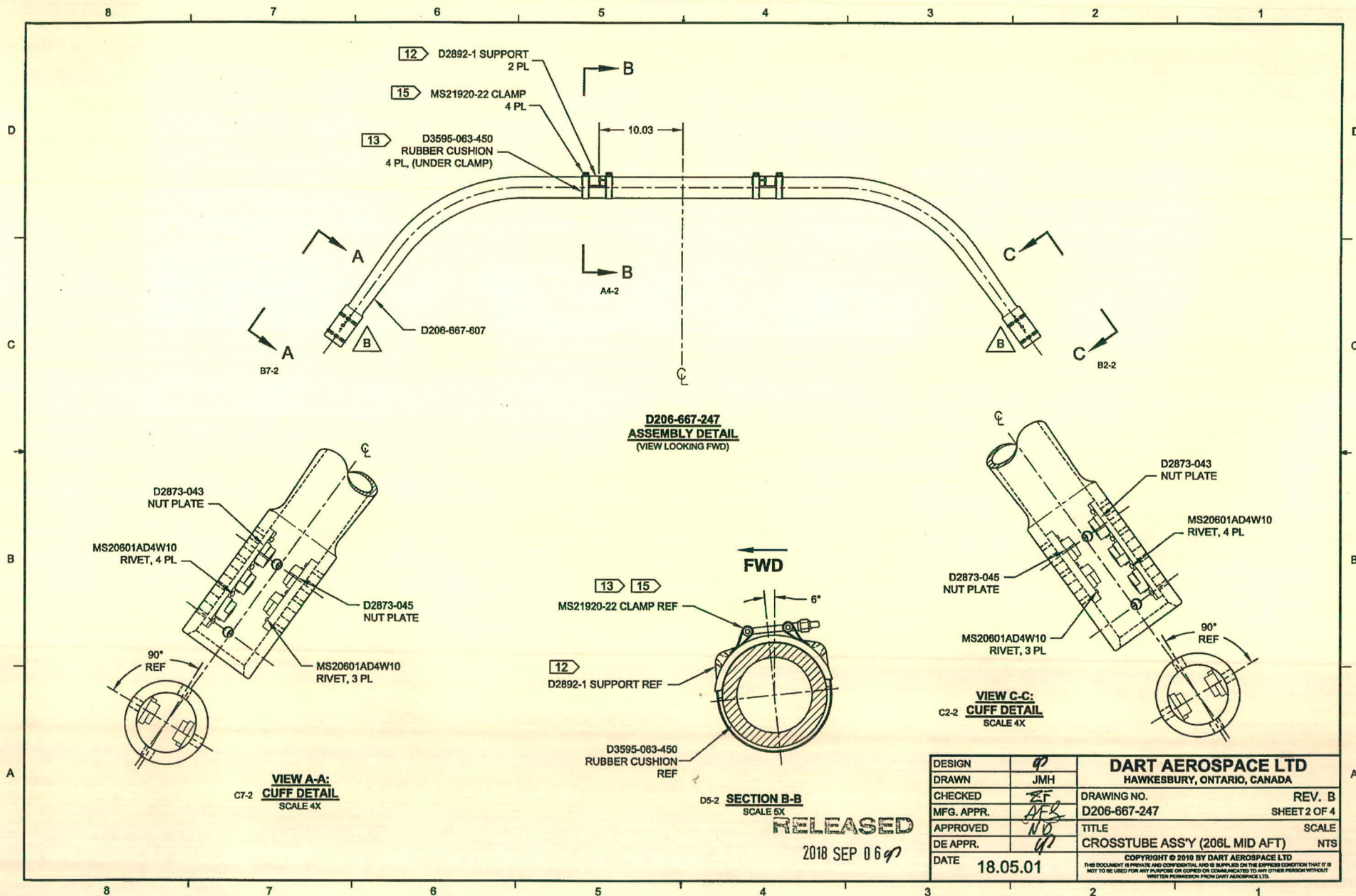
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 186179 ML5
18-1172

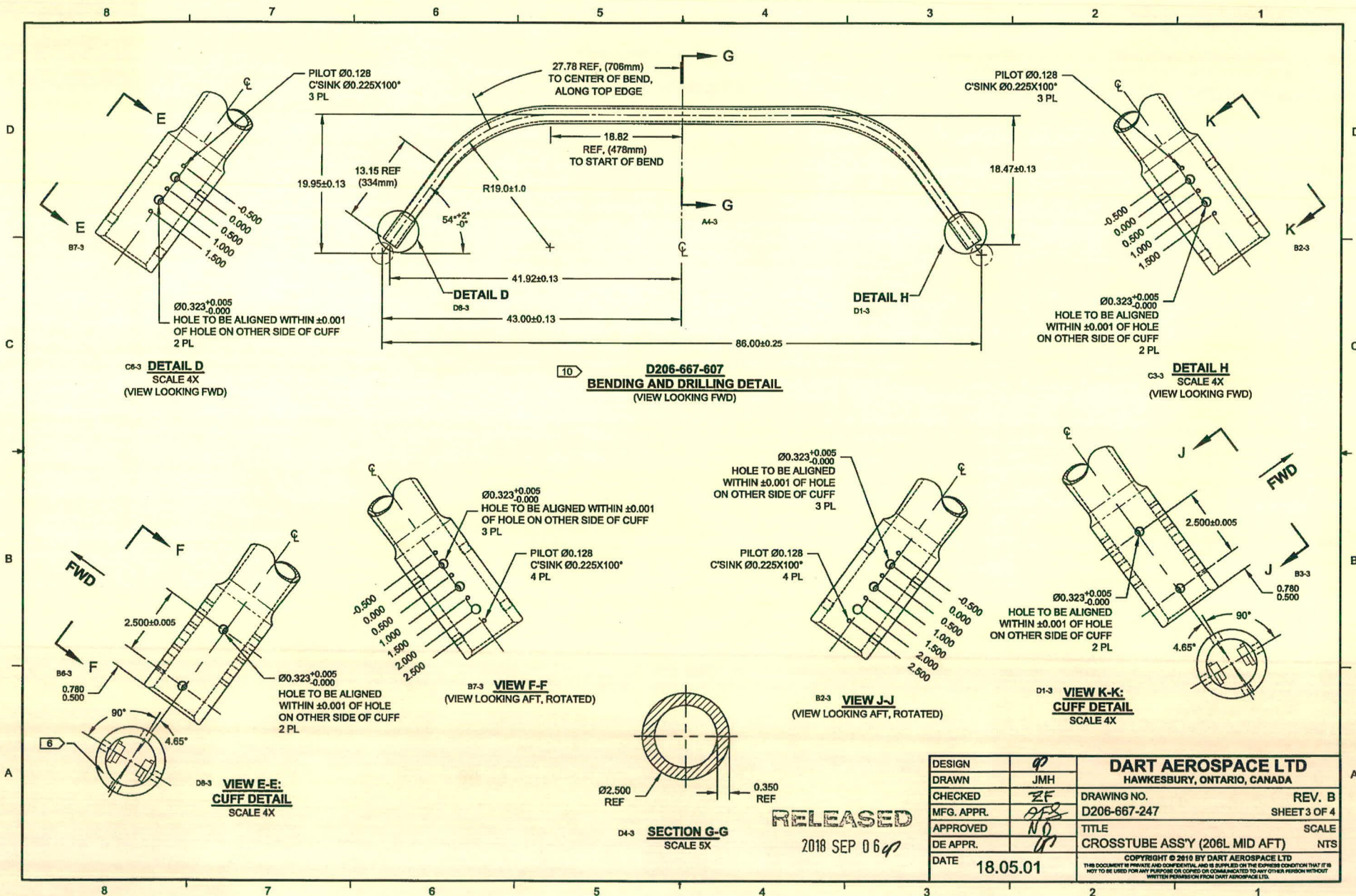
RELEASED

2018 SEP 06
ECN 18-777

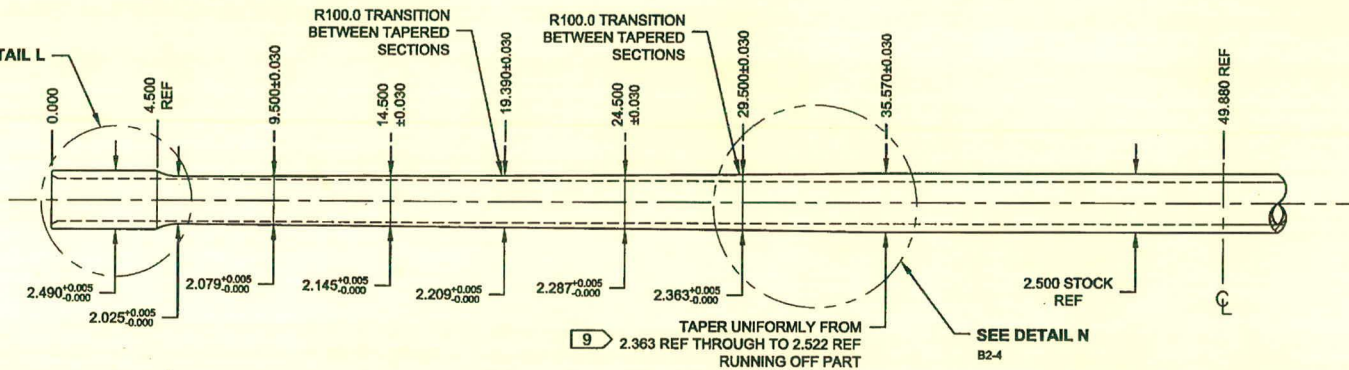
B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1.	JMH	18.05.01
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. B
CHECKED	ZF	D206-667-247	SHEET 1 OF 4
MFG. APPR.	DFB	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DE APPR.	4	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.05.01		



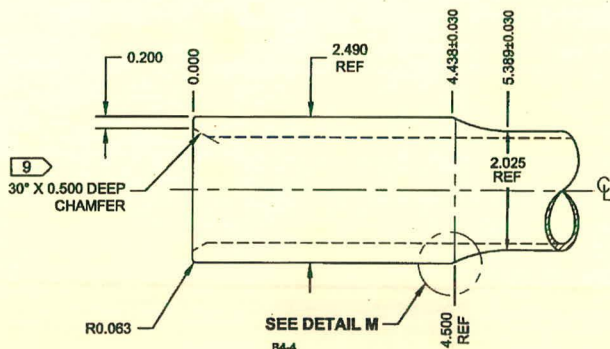
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DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 2 OF 4
APPROVED	ND	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (206L MID AFT) NTS	
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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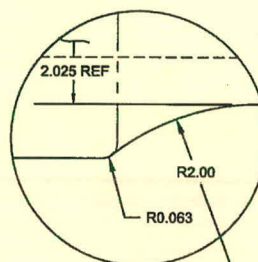
SEE DETAIL L
B7-4



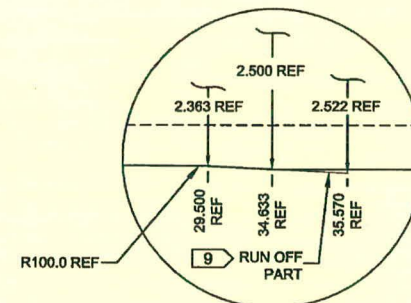
TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED

2018 SEP 06

DESIGN	q	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	q	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	18.05.01	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041903**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041903
PO Date: 11/29/18
Due Date: 12/4/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185375	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	12/4/18	1 pcs	0 pcs	1 pcs	\$172.00/pcs	\$172.00
2	186178	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	12/4/18	1 pcs	0 pcs	1 pcs	\$172.00/pcs	\$172.00
	186179			Firmed	-	12/4/18	1 pcs	0 pcs	1 pcs	\$172.00/pcs	\$172.00
Sub Total:							2	0	2		\$344.00

Plex 12/3/18 9:04 AM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

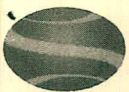
PURCHASE ORDER **PO041903**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186174	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	12/4/18	1 pcs	0 pcs	1 pcs	\$172.00/pcs	\$172.00
	186177			Firmed	-	12/4/18	1 pcs	0 pcs	1 pcs	\$172.00/pcs	\$172.00
Sub Total:							2	0	2		\$344.00
Grand Total:										\$860.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/3/18 9:04 AM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38417	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041903
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
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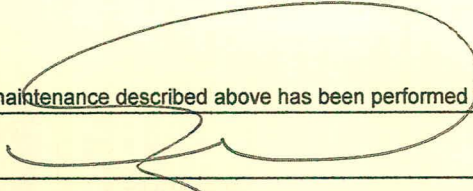
Work Required:**CARRY OUT NDT ON:**

- ✓ 1 FWD CROSSTUBE , P/N# D212-664-101 , J/S# 185375
- ✓ 2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 186174 , 186177
- ✓ 2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 186178 , 186179

Action Taken:	Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142	NOV 30 2018	 

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: NOV 30 2018
Name: RAFIK MELIKIAN		

